

Work Order ID 128828

128828

Page 1

Tuesday, January 27, 2015 7:49:05 AM

Item ID: D3260-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spring
 Start Date: 1/26/15 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 1/26/15 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 15-01-29 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3260	Rev A

100 PURCHASING 0.00
100
 Purchasing Memo 0.00
 Purchasing Issue P/O: 27321 Make as per Dwg D3260 Possible Supplier:
 Victory Spring Material release note is required

MLJ 15-02-03 (20)

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110
 Packaging Memo 0.00
 Packaging Ensure Material Release Note is attached

20 DAS 8-89 FEB 24 2015

120 QC6- Inspect dimensions to drawing 0.00
120
 QC Memo 0.00
 Quality Control

(20) DAS 38 9-89 FEB 24 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>St031</u>	0.00							
130						20			
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
66
8-09

FEB 26 2015

MLJ

15-02-26

MF
15-2-26

DQA: _____ Date: _____

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 1

Tuesday, January 27, 2015 7:49:05 AM

Work Order ID: 128828

128828

Parent Item: D3260-1

D3260-1

Parent Item Name: Spring

Start Date: 1/26/15

Required Date: 1/26/15

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A04.03.29New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3260-1P		Purchased		No		100	Each	0.0000	1	20			

D3260-1P

Spring

~~DAS~~

~~66~~

~~9-69~~

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Material									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

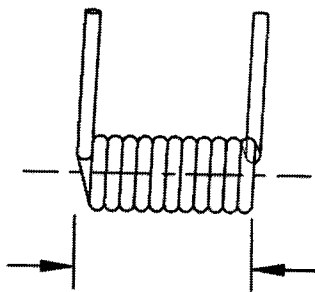
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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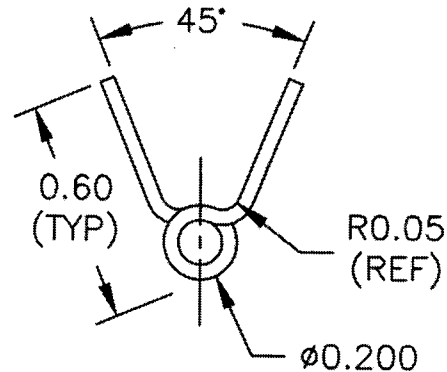
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3260	REV. A SHEET 1 OF 1
DATE 04.02.27		TITLE SPRING	SCALE 2:1
A	04.02.27	NEW ISSUE	

RELEASED
04.04.07 *[Signature]*

SPECIFICATION CONTROL DRAWING



$\phi 0.040$
12 COIL
(REF 0.480)



D3260-1 SPRING

D3260-1 NOTES:

- 1) MATERIAL: AISI 302 SS SPRING WIRE $\phi 0.040$ PER ASTM A313
(MIN TENSILE STRENGTH = 250 ksi)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

128828
MCS
15-01-29

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27321**

Purchase Order Date 2/3/2015

PO Print Date 2/3/2015

Page Number 1 of 2

Order From :

VC-VIC002

Ship To : DART AEROSPACE LTD

VICTORY SPRING LTD.
#2 6104 - 82 AVE.
EDMONTON, AB T6B 0E7
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 866 230 5312

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3260-1P AS PER DWG.D3260 REV.A B128828	Spring	2/17/2015 Yes 2/17/2015		20.00 Each	\$9.25	\$185.00
Line Total:							\$185.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	2/17/2015 No 2/17/2015		1.00	\$0.00	\$0.00
Procurement Quality Clauses A005 RIGHT OF ENTRY A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE) A016 PERSONNEL QUALIFICATION A026 CERTIFICATION OF MATERIAL CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS							

Note:

2/3/2015



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27321**

Purchase Order Date 2/3/2015

PO Print Date 2/3/2015

Page Number 2 of 2

Order From :

VC-VIC002

VICTORY SPRING LTD.
#2 6104 - 82 AVE.
EDMONTON, AB T6B 0E7
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 866 230 5312

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Total: \$0.00

PO Total: \$185.00

W
CL MCT

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 2/3/2015



PACKING SLIP

32038

#2, 6104 - 82 Ave
Edmonton, AB T6B 0E7
t + 780 442 4020
f + 780 466 8000

BILL TO: Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

SHIP TO:

DATE		ORDER No.		SHIP VIA	
23-Feb-15		PO27321		FedEx Collect	
QUANTITY	DESCRIPTION			UNIT	AMOUNT
20	D3260-IP Torsion Springs 15/02/23 SV				
GST #	TERMS	SUBTOTAL	FREIGHT	GST	TOTAL
854454527	NET 30 DAYS				

CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace Ltd.	DATE: 2/20/2015
PART/DRAWING #: D3260-1P	PO # PO27321
DESCR: Torsion Spring	QUANTITY: 20

VICTORY SPRING CERTIFIES BY THIS DOCUMENT THAT ALL OPERATIONS ARE DONE ACCORDING TO
DRAWINGS AND SPECIFICATIONS

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS 302	yes	
Material diameter	0.040"	0.041"	
Coil I.D.		0.122"	
Coil O.D.	0.200"	0.204"	
Number of Coils	12 ref.	12.1	
Free Length	0.480"	0.491	
End Type	per dwg.	YES	
Helix	LHW	LHW	

Mill Certificate attached: Yes
Material Heat Number: SO5114

Inspected by: *Jeremy Burrowes*

MATERIAL CERTIFICATION

REPORT FOR: Dart Aerospace Ltd.	DATE: 2/20/2015																						
PART/DRAWING #: D3260-1P	PO # PO27321																						
SPRING DESCRIPTION: Torsion Spring	QUANTITY: 20																						
MATERIAL GRADE: T302 Stainless Steel Wire Spring ASTM-313-03																							
PROPERTIES: <table> <thead> <tr> <th><u>Chemical</u></th> <th><u>Physical</u></th> </tr> </thead> <tbody> <tr> <td>Carbon: (C) 0.076</td> <td>Size: 0.041"</td> </tr> <tr> <td>Chromium: (Cr) 18.242</td> <td></td> </tr> <tr> <td>Copper: (Cu) 0.259</td> <td>Tensile: 293,000</td> </tr> <tr> <td>Manganese: (Mn) 1.237</td> <td></td> </tr> <tr> <td>Molybdenum: (Mo) 0.149</td> <td></td> </tr> <tr> <td>Nickel: (Ni) 8.039</td> <td></td> </tr> <tr> <td>Nitrogen: (N) 0.045</td> <td>Heat # SO5114</td> </tr> <tr> <td>Phosphorus: (P) 0.029</td> <td></td> </tr> <tr> <td>Silicon: (Si) 0.472</td> <td></td> </tr> <tr> <td>Sulphur: (S) 0.0037</td> <td></td> </tr> </tbody> </table>		<u>Chemical</u>	<u>Physical</u>	Carbon: (C) 0.076	Size: 0.041"	Chromium: (Cr) 18.242		Copper: (Cu) 0.259	Tensile: 293,000	Manganese: (Mn) 1.237		Molybdenum: (Mo) 0.149		Nickel: (Ni) 8.039		Nitrogen: (N) 0.045	Heat # SO5114	Phosphorus: (P) 0.029		Silicon: (Si) 0.472		Sulphur: (S) 0.0037	
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Mill Source: DSR Origin Country: Korea																							

Certified by: Jeremy Burrowes

Victory Spring Ltd. certifies this to be a true & accurate copy of the original contained in the company records.